

Process Sheet

Split 2

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 34807		Part Number	: D35649	
Estimate Number	: 12784		Drawing Number	: D3564 REV D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/21/2007 S.O. No. : N/A		Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: 9/21/2007 Type : SMALL /MED FAB		Due Date	: 10/5/2007	
Previous Run	: 33804		Qty:	30	Um: Each
Written By	: <u>AD</u> 07-09-24				
Checked & Approved By	: <u>AD</u> 07-09-24				
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304S16GA	304/316 0.063 Sheet	
		30.2841 sf	
		Comment: Qty.: 0.9177 sf(s)/Unit Total: 27.5310 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>105844</u> <u>1B C7-10-11</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ****(D3564-1F)**** Dwg Rev: <u>4</u> <u>1B C7-10-11</u> Prog Rev: <u>8</u>	
		2-Deburr if necessary <u>1B C7-10-11</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>1B C7-10-11</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		<u>1B C7-10-11</u> counter	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		Deburr if necessary	
		Form on Brake as per Dwg D3564 using Jigs DT-1 and DT-5155	
		Form Joggle as per Dwg D3564 on brake using Jig DT 5157	

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Customer: CU-DAR001 Dart Helicopters Services

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Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/10/17 1033 counter

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M 105594

Weld hardcoat as per Dwg D3437

FC 07 10 23 10

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/10/23 10

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/23 10 counter

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

PL 07-10-24

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-24

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-15

PL

07-10-24

10

13.0 QC21

FINAL INSPECTION/W/O RELEASE



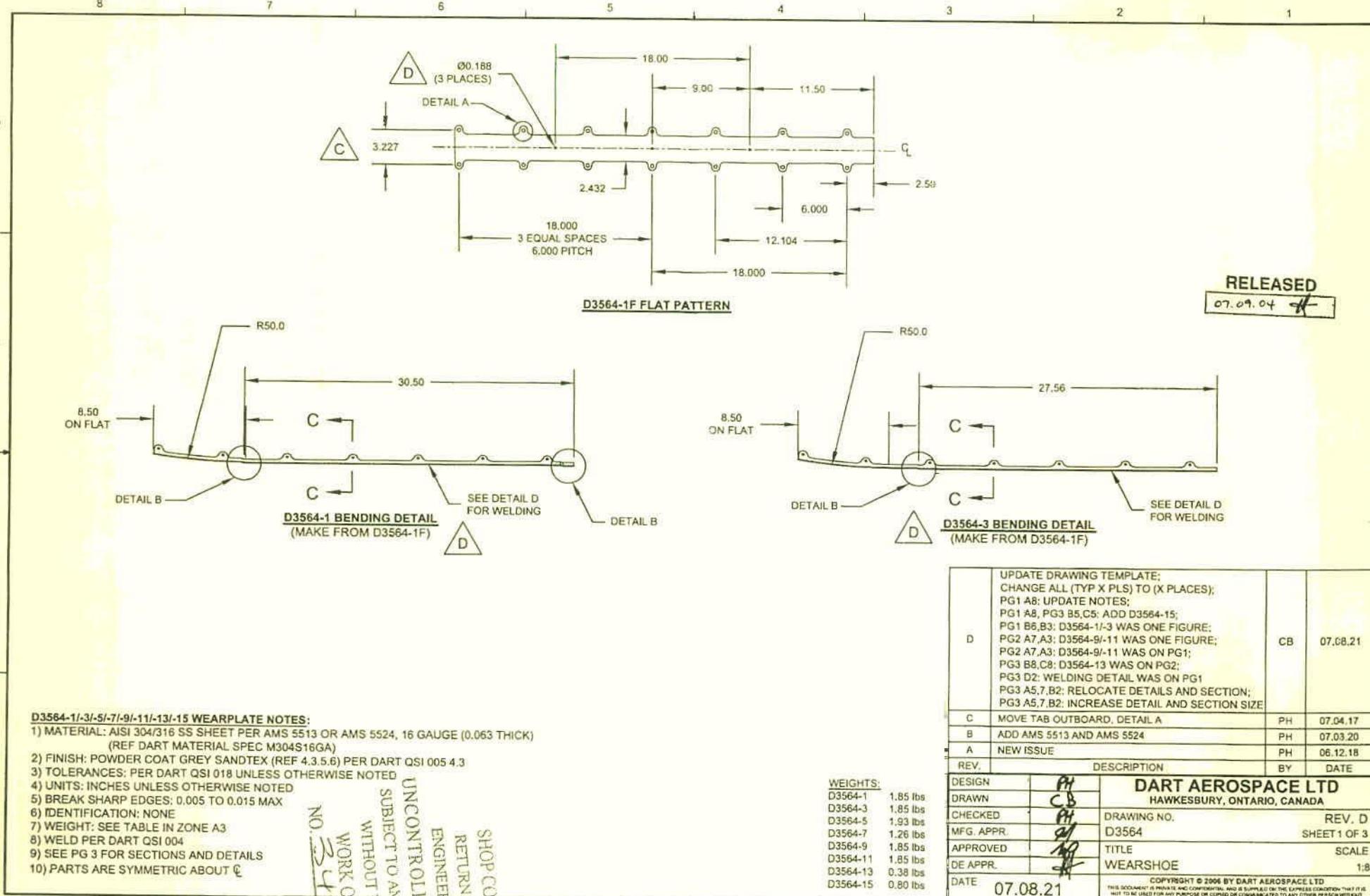
Comment: FINAL INSPECTION/W/O RELEASE

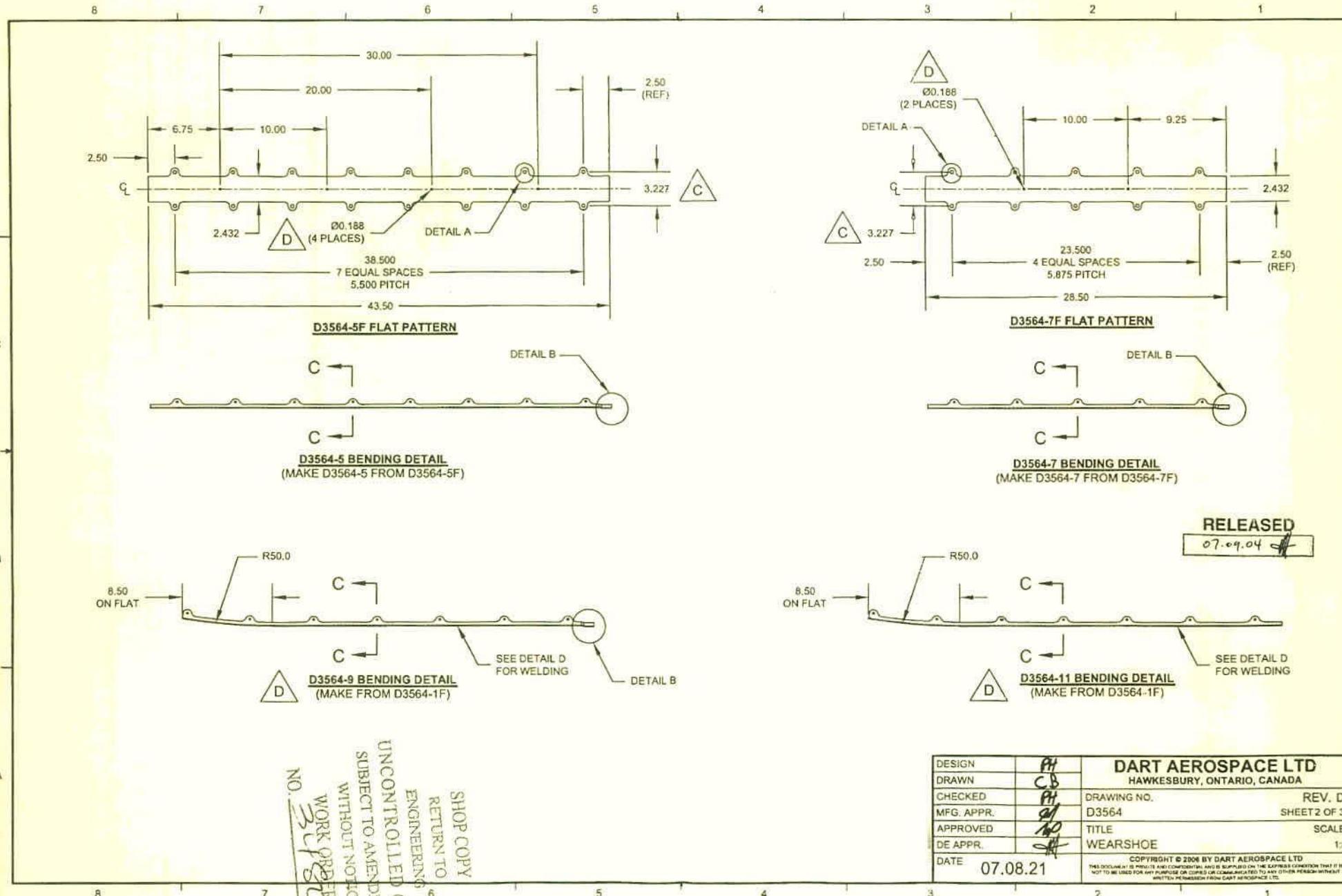
PL 07/10/25

Job Completion



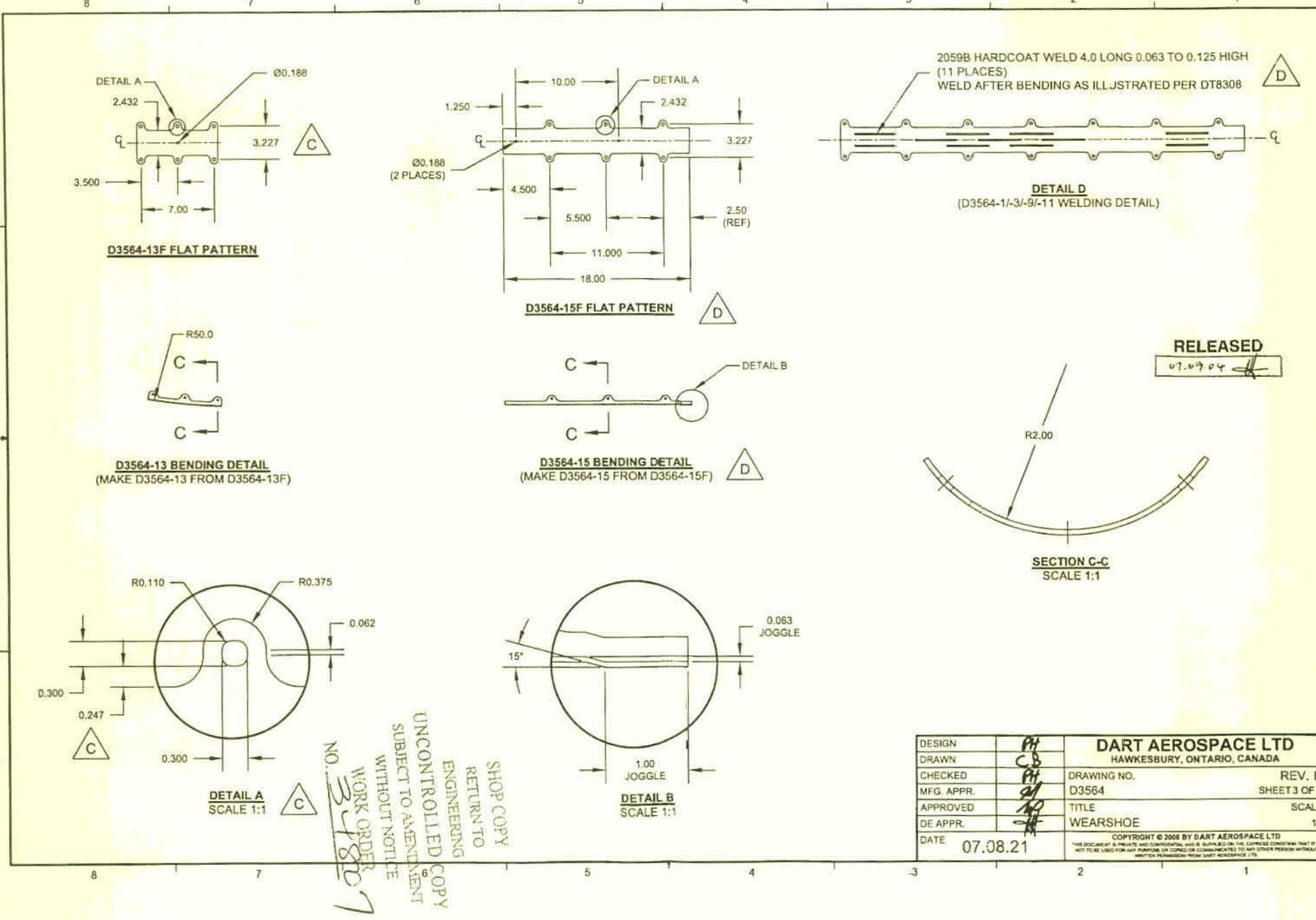
PL 07-10-25





DESIGN	PH	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3564
MFG. APPR.	PH	REV. D
APPROVED	PH	SHEET 2 OF 3
DE APPR.	PH	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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DART AEROSPACE LTD		Work Order:	34807
Description: WEAR PAD		Part Number:	D 3564-9
Inspection Dwg: D 3564 Rev: 0			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>LN</u>	Prototype Approval: <u>1/1</u>
Date: <u>07-10-14</u>	Date: <u>21/01/15</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

